

5/45

DART AEROSPACE LTD	Work Order:	24632
Description: Fitting	Part Number:	D3198-1
Dwg: D3198 Rev. A	Qty:	60
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	YJ	05.10.21	60
2	PG	Issue P/O: 2008552 Email or Ship DXF file to vendor Laser Cut D3198-1 fitting as per Dwg D3198 Material release note is required	AP	05/10/21	60
3	RG	Receive and Inspect for transit damage Ensure material release note is attached	LO	05/11/21	61
4	QC6	Inspect dimensions as per Dwg D3198	SB	05/12/05	61
5	GA	Deburr if necessary	SB	05/12/05	61
6	GB	Form D3198-1 as per Dwg D3198 Identify as D3198-1	SB	05/12/05	61
7	QC5	Inspect work to Step 6	2	05-12-05	61
8	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	ML	05 12 06	61
9	QC3	Inspect Powder Coat	CL	05/12/07	61
10	ST	Identify and Stock	CL	05/12/07	61
11	AC	Cost / part	SAE	05-12-09	61
12	DC	Close W/O Inspect Level 21	AP	05/12/08	61

Rev	Date	Change	Revised By	Approved
A	03.11.11	New Issue	KJ/RF	RF

RELEASED

04.01.06 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

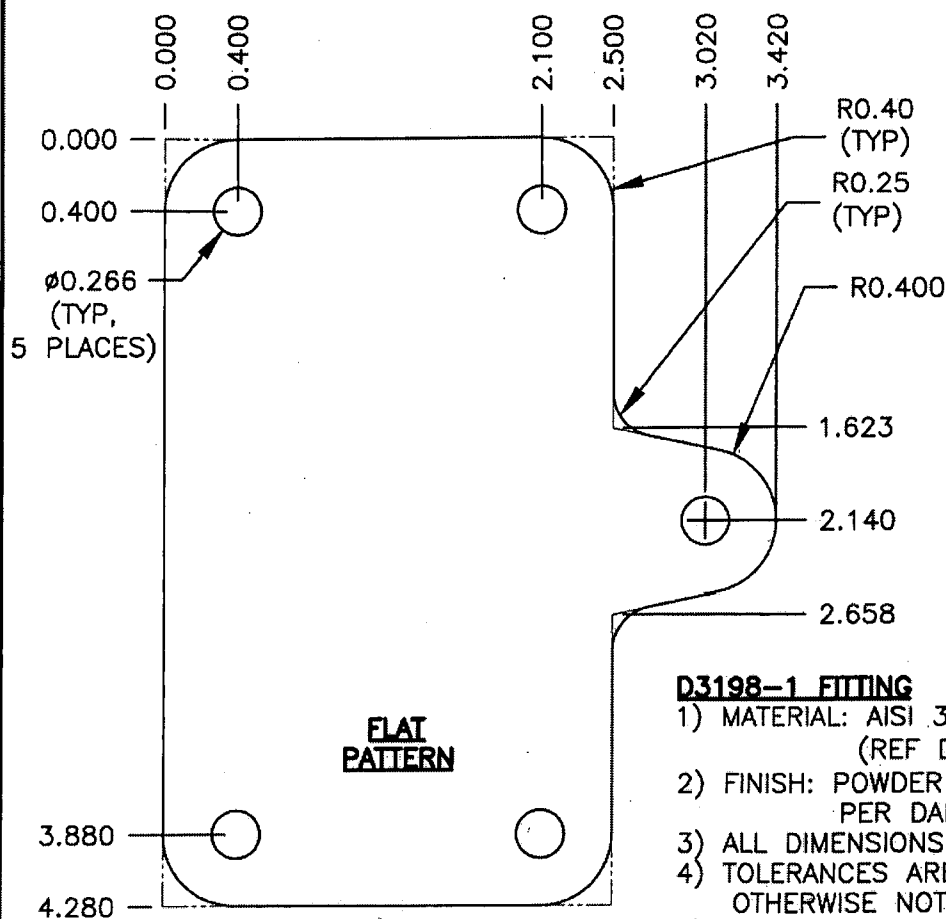
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/12/08

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3198	REV. A SHEET 1 OF 1
DATE 03.09.26	TITLE FITTING		SCALE 1:1
A	03.09.26	NEW ISSUE	

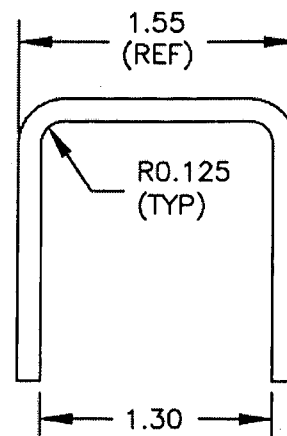
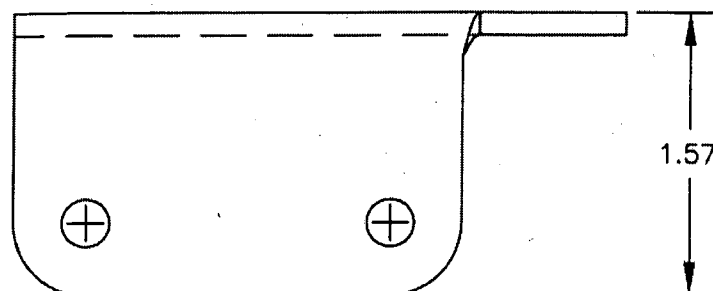


24632

D3198-1 FITTING

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED
03.10.10



**BEND
DETAIL**

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 20, 2005
04:09 pm

Work Order No : 0024632
Project Name : D3198-1
Project For : WK545
Work Order Type : Main
Main WO Number :
House Part Number : D3198-1
Description : Fitting
Manufactured : Yes
Amount Req'd : 60
Amount Done : 0
Start Date : 10-20-05
Est Finish Date : 11-10-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

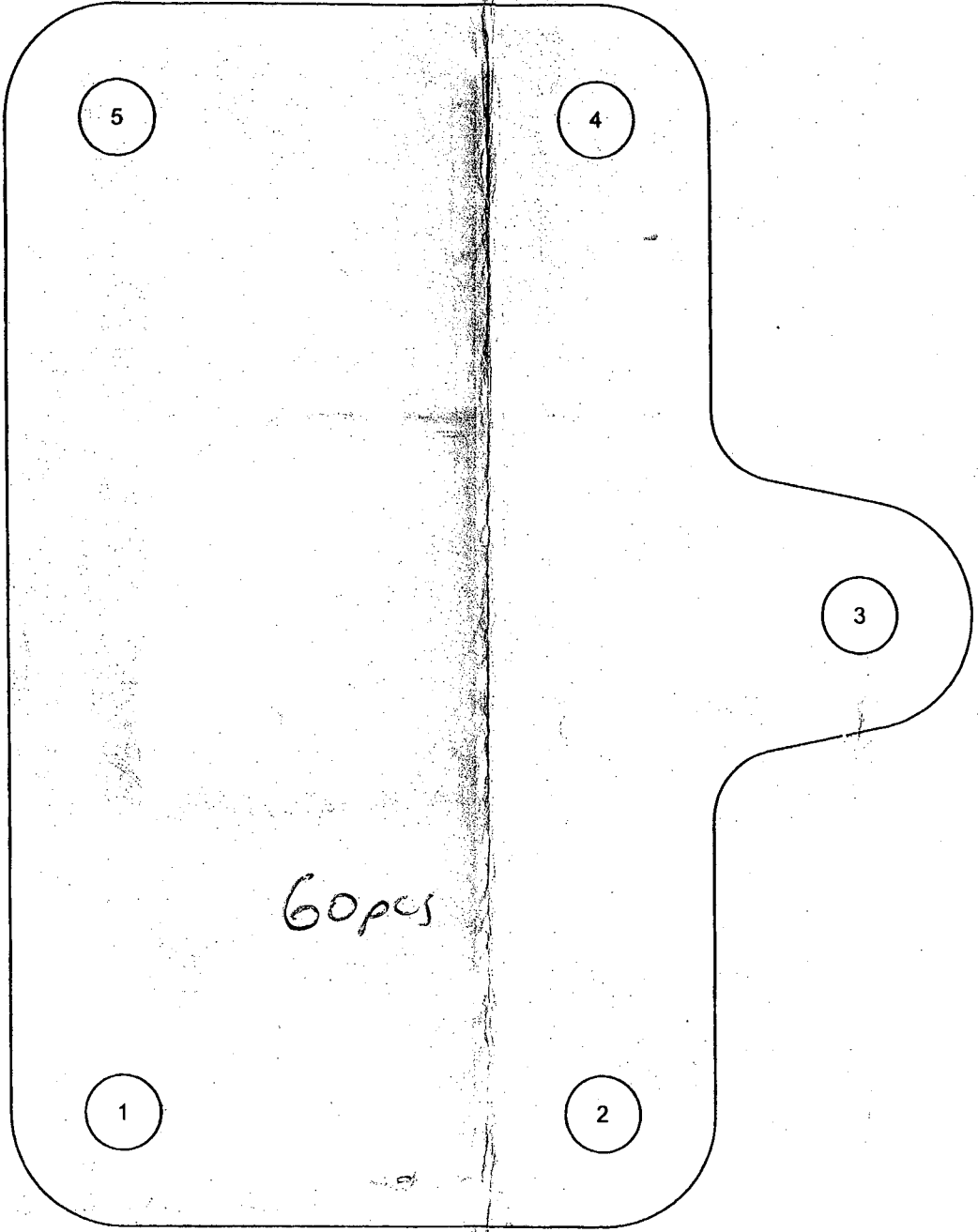
Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Drawing name..... D3198REVA
Revision.....
Material number..... 0032, STAINLESS 11GA, 12
Last modified date... 11-14-2005
Programmed by..... jm

Comment.....
Customer name... dart
Description.....
Specification.....



Cutting distance = 18.2091
Rapid distance = 10.8571

4.28 x 3.42
1 = .5



Certified in accordance to Pressure Equipment Directive 97/23/EC Annex I,
Paragraph 4.3 by TÜV Anlagentechnik GmbH (Notified Body Identification No.0035)
Inspection Certificate EN10204-3.1B

**Shanxi Taigang Stainless Steel CO.,LTD Member
of Taiyuan Iron and Steel (Group) Co.,LTD**

NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China

TEL: (0351)3013328 FAX: (0351)3017816

http://www.tisco.com.cn

E_mail: tgbxg@tisco.com.cn

INSPECTION CERTIFICATE

MATERIAL	AISI304 No.2B Finish	
SPECIFICATION	ASTM A240/A480	ASME SA240/SA480
L/C NO.		
CERTIFICATE NO.	20050649	
DATE OF ISSUE	/ /	

CUSTOMER
Marubeni-Itochu Steel CA.

CONTRACT NO.
V-1140-05

P50321PC002

DATA OF
2005/06/20

Product: Melting furnace Inspectors stamp Mark of the Manufacturer
COIL E+VOD  Shanxi Taiyuan Stainless Steel Co.,ltd

NO.	Heat No.	Coil No.	Quantity	Dimensions	Weight (kg)
1	4501710	5A4-11-1ZD	1	11GA x 48 x C	3305
2	4501680	5A4-64-4ZJ	1	14GA x 48 x C	5067
3	4501707	5A4-4-1ZB	1	14GA x 48 x C	4822
4	Y501955	5A4-58-4ZJ	1	14GA x 48 x C	4807
5	4501356	5A4-12-1ZB	1	12GA x 48 x C	3593
6	4501710	5A4-13-1ZD	1	11GA x 48 x C	3225
7	4501710	5A4-14-1ZD	1	11GA x 48 x C	3395

Chemical Composition

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4501710	0.050	0.520	1.360	0.023	0.002	18.030	8.090				0.040
4501680	0.060	0.470	1.340	0.016	0.003	18.140	8.110				0.060
4501707	0.060	0.460	1.350	0.018	0.002	18.100	8.100				0.050
Y501955	0.062	0.460	0.990	0.034	0.003	18.090	8.030				0.057
4501356	0.060	0.490	1.310	0.017	0.002	18.160	8.070				0.050
4501710	0.050	0.520	1.360	0.023	0.002	18.030	8.090				0.040
4501710	0.050	0.520	1.360	0.023	0.002	18.030	8.090				0.040

Mechanical Properties

Test No.	Tensile R m N/mm ²	R _{0.2} Yield _{0.2%} N/mm ²	R _{P1.0} Yield _{1.0%} N/mm ²	Elongation A5%	Corrosion Tests	Hardness		
						HRB	HV	HRC
4501710-T	665	287		57		85		
4501680-T	680	305		57		86		
4501707-T	665	290		58		84		
Y501955-T	685	321		57		87		
4501356-T	680	290		58		86		
4501710-T	665	287		57		85		
4501710-T	665	287		57		85		

Surface and dimensions controlled: O.K.

Work Inspecto

[Signature]